












642-212

Dart Aerospace Ltd.

Date: Thursday, 19/02/2009 1:57:57 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
<b>Job Number</b>	: 45906A		
<b>Estimate Number</b>	: 10163		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D206642241
<b>This Issue</b>	: 19/02/2009	<b>S.O. No.</b>	:
<b>Prsht Rev.</b>	: NC	<b>Drawing Number</b>	: D2650 REV F
<b>First Issue</b>	: / /	<b>Project Number</b>	: N/A
<b>Previous Run</b>	: 45905A	<b>Drawing Revision</b>	: F
<b>Written By</b>	:	<b>Material</b>	:
<b>Checked &amp; Approved By</b>	: <u>Julie Dawson</u>	<b>Due Date</b>	: 09/03/2009
<b>Comment</b>	: Est Rev:M 04.12.02 Revised procedural steps KJ/JLM	<b>Qty:</b>	1 Um: Each
<b>Additional Product</b>			
Job Number: 			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
1.0	DC	DOCUMENT CONTROL	
			
<b>Comment:</b> DOCUMENT CONTROL Photocopy bluefile & type labels per PPP D206-642-241 CHG003 N/A <i>DP</i>			
2.0	D2620	Skidtube, 206 Skidtube	
			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2620 Bent Tube 3" OD <i>B44502 DP 9-2-19</i>			
3.0	D32861	Doubler	
			
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3286-1 Doubler <i>B44286 DP 9-2-23</i>			
4.0	D2647	Cap	
			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2647 Fwd Cap <i>B43846 BE 9-2-20</i>			
5.0	SKIDTUBES 1	SKIDTUBE RESOURCE 1	
			
<b>Comment:</b> LANDING GEAR RESOURCE 1 1-Deburr Fwd edge of tube <i>DP 9-2-19</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 45906A

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Job Number:



Seq. #:

Machine Or Operation:

Description :

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

DP 9-2-19

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

Pick:

Qty Part Number Description Batch

A/R

Aluminum Rod

m110676/m109213 BE 9-2-20

4-Grind weld flush to cap on top surface only.

BE 9-2-20

5-Cut Aft end as per dwg 2650 from front of tube and Deburr

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025.

8-Drill pilot holes using Dt 8167.

9-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support.

10- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time.

11-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads.

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder

14-Remove indexing edge using DT8741 as per Dwg D2650

15-C'sink GHW rivet holes as per Dwg D2650

) H 9-2-24

6.0

QC6

DIMENSIONAL CHECK



holes with in 0.05"  
From side to side



Comment: DIMENSIONAL CHECK

S 09/02/24 (H)

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to Ø0.3125"

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6.

3-Deburr tube and blow out chips from inside the tube

*JP 09/02/24*

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*DM 9-2-24*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*JP 9-2-24*

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr and blow out all chips from inside the tube

*JP 9-2-24*

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*holes are still aligned.*

*JP 09/02/24*

12.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet *16299*

*15 9-2-24*

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D26543

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2654-3

Web

045910

① M

9-2-24

14.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 9-2-24 Time: 9:50

Finish Date: 9/2/25 Time: 8:20 AM

Pick:

Qty Part Number

Description Batch

A/R Sikaflex-291

M109383

Sikaflex expire date:

9-7-1

M  
9-2-24

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9/2/25 (X)

16.0

D2649

Cross Bolt Spacer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description Batch

18 D2649

Crossbolt spacer

B44364

BE 09/02/25

17.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3286-3

Spacer

B44362

BE 09/02/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-remove alodine from around hole and prepare for welding

BE 09/02/25

2-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod

M109213

BE 09/02/25

3-Grind welds flush as per Dwg D2650.

K 9-2-26

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.402" before welding other side. Use SS rod as required.

A/RSS Rod

NONE

BE 09/02/26

5-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr

K 9-2-27

19.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets

M110625

②

K 9-2-27

20.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivet

batch:

11239

②

K 9-2-27

21.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041

Nut Plate

M 34599

①

K 9-2-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

HA-2-27

23.0

QC9

+QC10

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

QC10 - 509/02/27

QC9 - PD 09-02-27

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

509/02/27

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

PR 09-03-2 ①

26.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs.

START TIME:

6:20

OVEN TEMPERATURE:

320°

FINISH TIME:

6:50

FD 09/03/03 ①

27.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-04

①

28.0

D26483

Wearpad



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2648-3

Wearpad

B44548

HD 09-03-04 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No: DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 45906A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-13

Wearshoe

1342772

*js /cmd*

30.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-21

Wearshoe

1342776

*js /cmd*

31.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-33

Wearshoe

BAUT 35 43806

*js /cmd*

32.0

D34291

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad

1344169

*js /cmd*

33.0

ALS41032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

~~44~~ ALS4-1032-130 Inserts

1108606

or (see QSI 017)

*js /md 09-03-04*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
02/03/05	31.0	Change Batch : B41736 For Batch: B43806. B41736 was batch of D2656-31	FR/ MD	02/03/05				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Seq. #:

Machine Or Operation:

Description :

34.0

AN960JD10L

Washer



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

46 AN960JD10L

Washer

11109632

jsl/cmo

35.0

MS27039108

Screw



Comment: Qty.: 46.0000 Each(s)/Unit Total : 46.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

46 MS27039-1-08

Screw

11110467

jsl/cmo

36.0

D26511

Plug



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

18 D2651-1

Plugs

1343990

jsl/cmo

37.0

D26513

O-Ring



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

18 D2651-3

O-Rings

1343849

jsl/cmo

38.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 MS27039-4-06

Screw

11109061

jsl/cmo

39.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN960JD416

Washer

11108161

jsl/cmo 09.03-04 (X)

W/O:		WORK ORDER CHANGES					
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Description :

40.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

✓ A/R Sikaflex-291 M109883

Sikaflex expire date: 09/11

✓ 2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650 (D2650-3 detail). Clean excess adhesive.

✓ 3-Install MS27039-4-06 Screw as per DEO 9153.

JSI/mo  
09-03-04 (X1)

41.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap B43801

JSI/cmo

42.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 M109883

Sikaflex expire date: 09/11

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch: M110454

JSI/cmo  
09-03-06 (X1)

43.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

44.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JSI/cmo  
09/03/06 (X1)

W/O:		WORK ORDER CHANGES					
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Description :

45.0

PACKAGING 1

PACKAGING RESOURCE #1



(1x)

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206664241 IF APPLICABLE

Location:

PPP Rev:

PPP

45906

9/3/11

SO

46.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/12

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



NLF  
09-03-12

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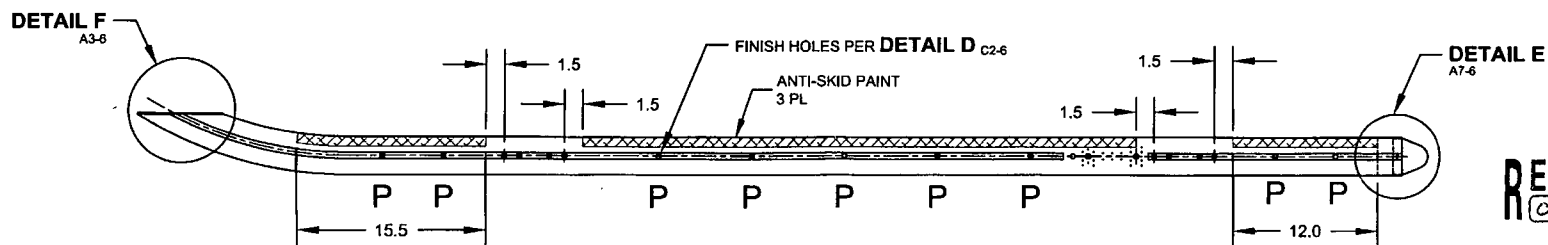
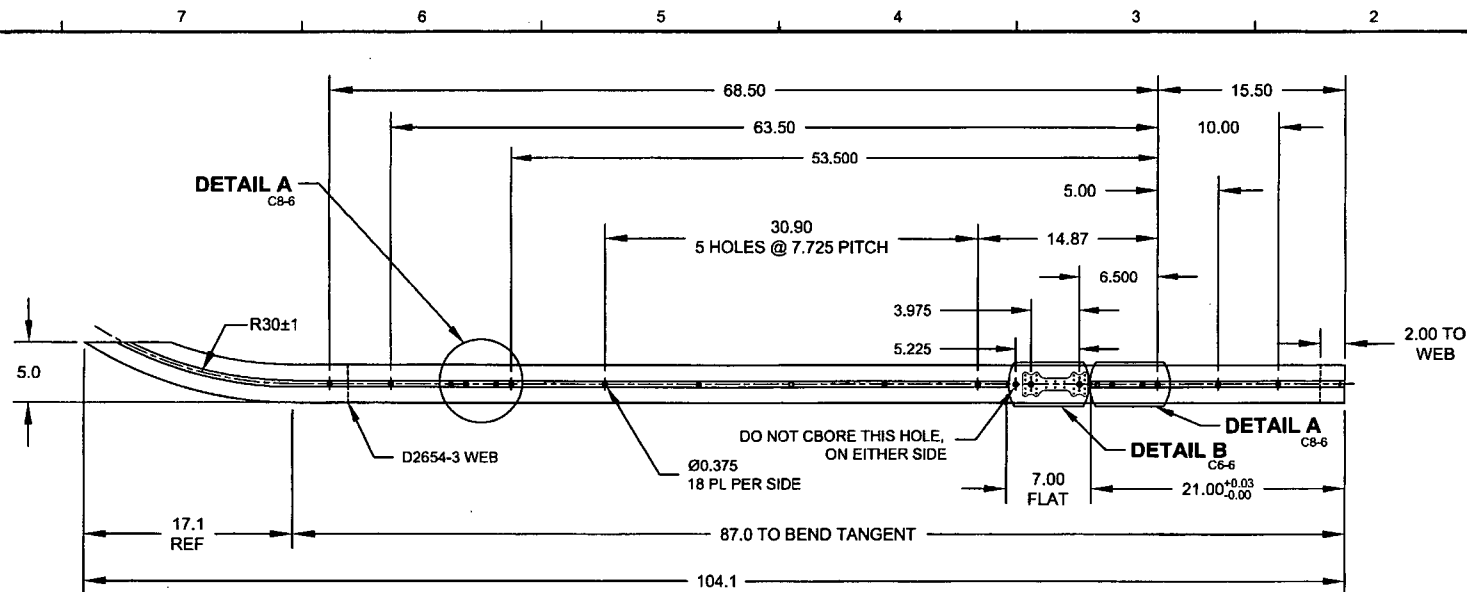


RELEASE  
68-0922-1114





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MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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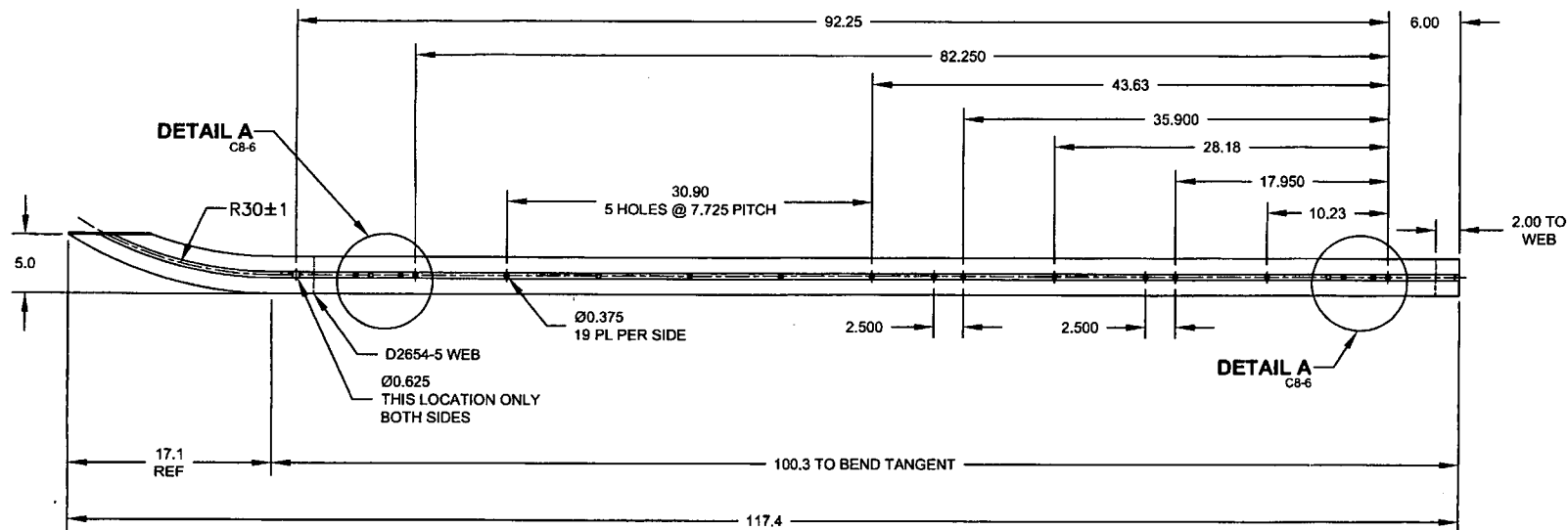
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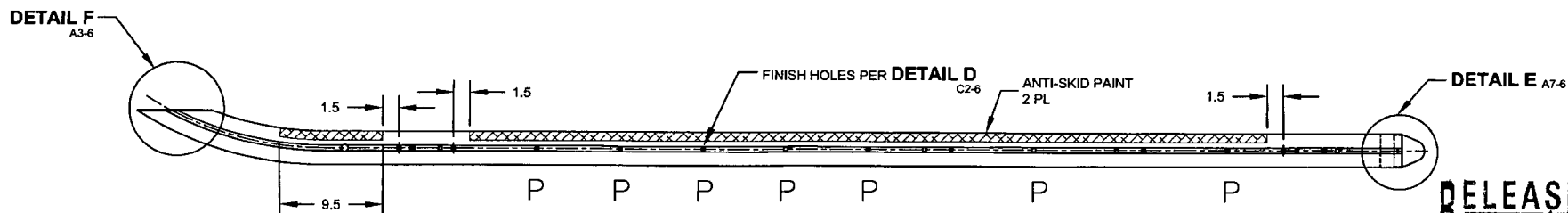
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MFG. APPR.		D2650	SHEET 3 OF 6
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**D2650-5 BENDING/DRILLING DETAIL**



**D2650-5 ASSEMBLY/FINISHING DETAIL**

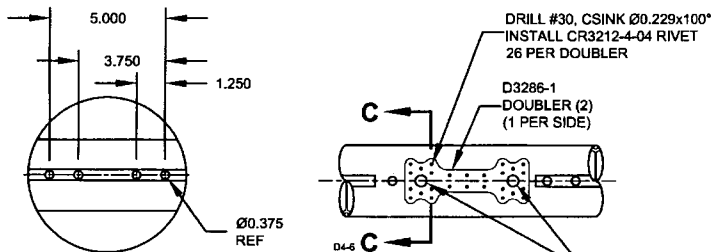
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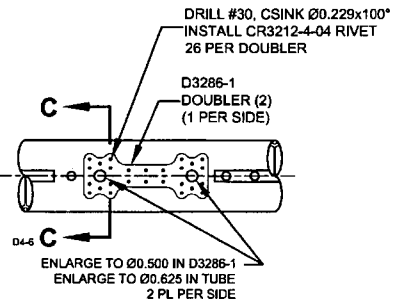
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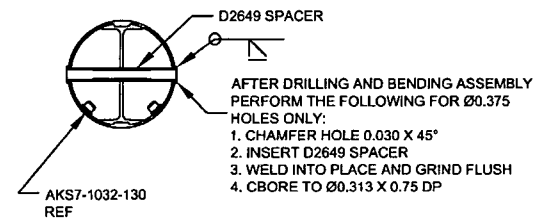
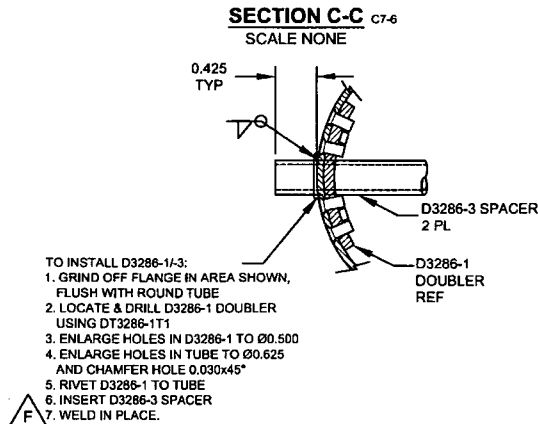




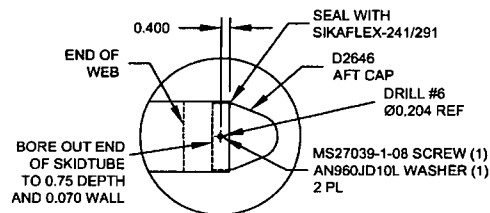
**DETAIL A**  
SCALE 2X  
C2-2  
D7-2  
C2-3  
D7-3  
C2-4  
D7-4  
C2-5  
D6-5



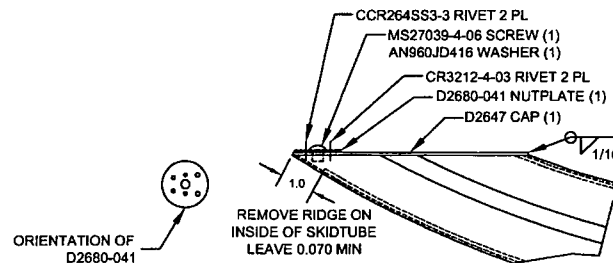
**DETAIL B**  
SCALE 2X  
C3-2  
C3-3



B4-2  
B4-3  
B4-4  
B4-5





**DETAIL E**  
SCALE 2X  
B2-2  
B2-3  
B1-4  
B1-5



**DETAIL F**  
SCALE NONE  
B8-2  
B8-3  
B8-4  
B8-5

- DETAIL F NOTES:**  
1. CUT TUBE LEVEL  
2. REMOVE RIDGE ON FWD SIDE  
3. LOCATE D2647 (TRIM AS NECESSARY)  
4. WELD D2647 IN PLACE PER DART QSI 004  
5. GRIND FLUSH  
6. RIVET D2680-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

**RELEASED**  
08-09-22-19

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**AWS D17.1.2001**  
**QUALIFICATION TEST RECORD**

Name: Barclay Elliot  
Job number: 45124 A  
Part number: D058 670 041 / D206 642 241  
Description: 04 58 / 206 skid  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[ ] DC[ ]

**TEST REQUIREMENTS AND RESULTS**

Visual:  
Penetration:

pass[☒] fail[ ]  
pass[☒] fail[ ]

**UNACCEPTABLE**

Cracks:  
Undercut:  
Pin holes:  
Overlap (cold lap)  
Porosity (surface):  
Coloration:

pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]  
pass[☒] fail[ ]

Qualifier Pet. Dignel Date of Test Coupon 9-1-28  
Welder Barclay Elliot Date of Test Coupon 9-1-28

The above named individual is qualified in accordance with AWS D17.1.2001 to weld